

Work Order ID 52263

September 22, 2009 8:06:53 AM

Page 1

Item ID: D3048-1

Revision ID: A2

Item Name: Doubler

Start Date: 9/22/09 Start Qty: 8.00

Required Date: 9/25/09 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: *W*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3048

Rev A2

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3048
Deburr if necessary

Dwg Rev: A2

Prog Rev: A2 2-

IB 9-9-02

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-9-02

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2> 8/30/02

(X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52263

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Item ID: D3048-1

Accept



Setup Start



Revision ID: A2

Item Name: Doubler

Stop



Start Date: 9/22/09 Start Qty: 8.00



Cust Item ID:

Required Date: 9/25/09 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form on CNC Brake per Dwg D3048

0.00

0.00

SD 09/09/23

8 8

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

el 09/09/23

8 8

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

BP 09-9-23

8 8

W/O:		WORK ORDER CHANGES					
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Work Order ID 52263

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Item ID: D3048-1

Accept



Setup Start



Revision ID: A2

Stop



Item Name: Doubler

Start Date: 9/22/09 Start Qty: 8.00



Cust Item ID:

Required Date: 9/25/09 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location:

CA

0.00



Packaging

Memo

0.00

Packaging

9/21/23

SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/24
ME 09-09-24

Picklist Print

September 22, 2009 8:06:52 AM

Page 1

Work Order ID: 52263

Parent Item: D3048-1RevA2

Parent Item Name: Doubler

Comments:

Start Date: 9/22/09

Required Date: 9/25/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	93.0033	29.1225	30.000		



2024-T3 .063 sheet



18 9-9-09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

93.00332419

102942

1.5

105916

3.69

106223

1.47

109463

0.00947368

110980

5.4854

111787

78.8484505

19059

2

11787

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

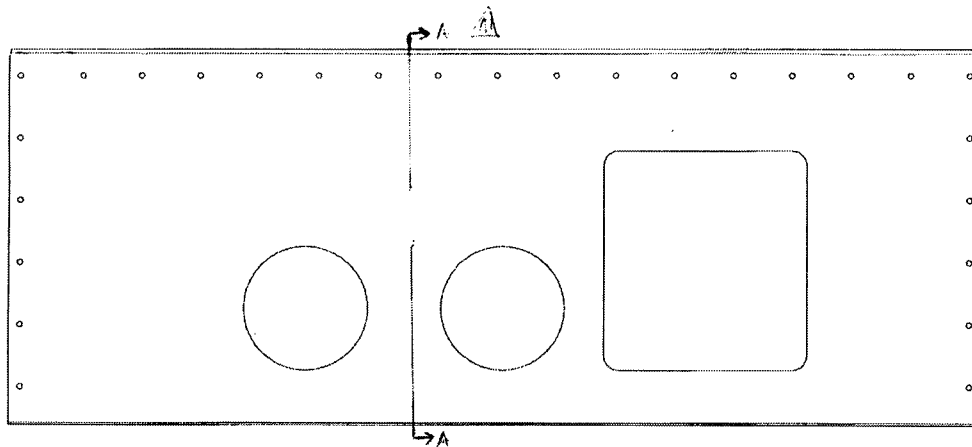
W/O:		WORK ORDER CHANGES					
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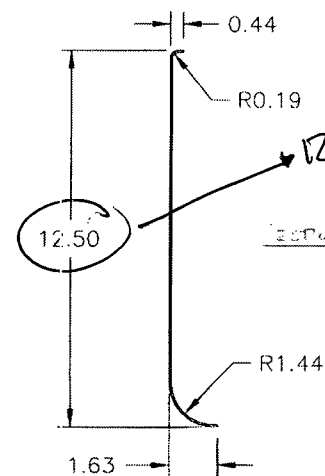
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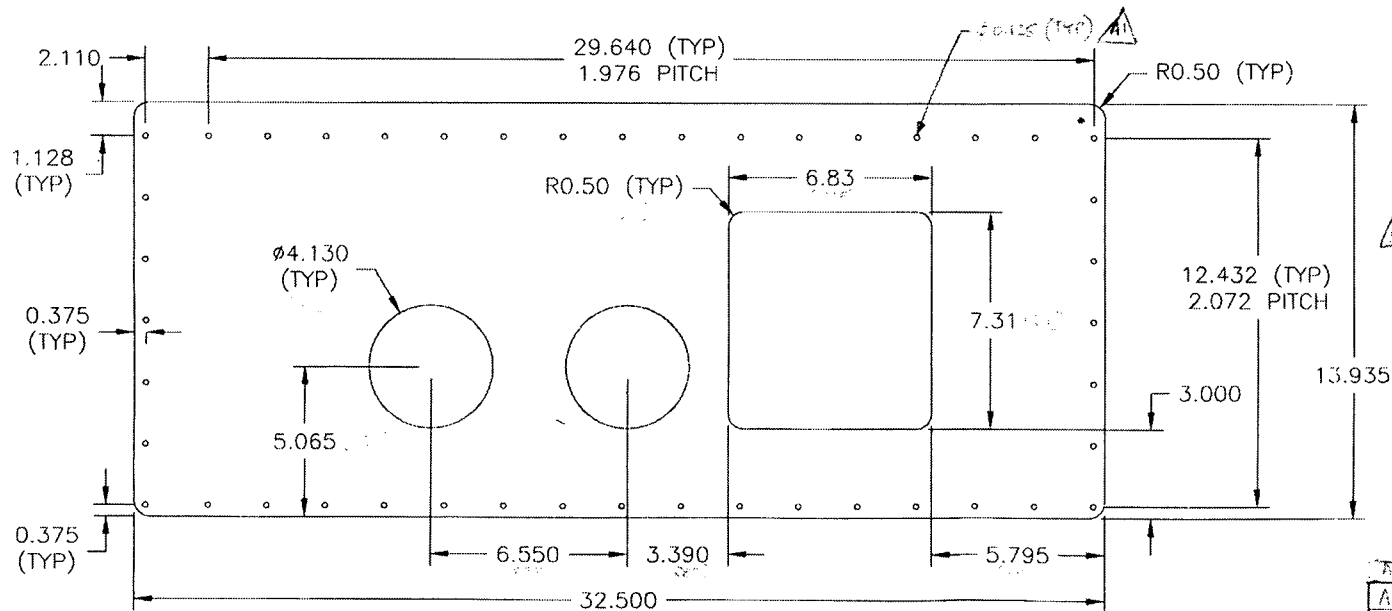


D3048-1



SECTION A-A

12.63 ± 0.06
ACCEPTABLE.
W/ 52263



D3048-1 FLAT PATTERN

MATERIAL: 2024-T3 (QQ-A-250/4)
0.063 THICK
FINISH: ACID ETCH, ALODINE PER DART
QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED



AI	02.11.20	COMPAT Draw Office
A	01.09.25	NEW ISSUE
DESIGN	DRAWN BY RT	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
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DATE	01.09.25	TITLE DOUBLER
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